

# Work Order ID 79341

**\*79341\***

Page 1

Wednesday, January 25, 2012 11:59:03 AM

Item ID: D4106-4 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Crew Door Doulber, RH  
 Start Date: 1/25/2012 Start Qty: 8.00 **\*8\*** Cust Item ID:  
 Required Date: 2/3/2012 Req'd Qty: 8.00 **\*8\*** Customer:

## Reference:

Approvals: Process Plan: MLJ Date: 12/01/25 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4106	A								

100 0.00  
**\*100\***  
 Waterjet  
 FLOW CNC Waterjet  
 304 .050  
 Memo  
 1-Cut as per Dwg  
 Dwg Rev: 1  
 Prog Rev: 1  
 2-Deburr if necessary  
 110 0.00  
**\*110\***  
 QC  
 Quality Control  
 Memo  
 QC2- Inspect parts off machine FAI/FAIB  
 12-2-21  
 12-2-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 79341



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Page 2

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Item ID: D4106-4 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Crew Door Doulber, RH  
 Start Date: 1/25/2012 Start Qty: 8.00 **\*8\*** Cust Item ID:  
 Required Date: 2/3/2012 Req'd Qty: 8.00 **\*8\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00					12	02	21 (9)
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									
130		0.00							
<b>*130*</b>									
Small Fab	Memo	0.00							
Small Fab	1- C'sink holes as per dwg								
140	QC5- Inspect part completeness to step on W/O	0.00					12	02	23 (9)
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

*EP 12/02/23 (9)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 79341****\*79341\***

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Wednesday, January 25, 2012 11:59:03 AM

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Revision ID: Stop **\*NS2\***  
Item Name: Crew Door Doulber, RH  
Start Date: 1/25/2012 Start Qty: 8.00 **\*8\*** Cust Item ID:  
Required Date: 2/3/2012 Req'd Qty: 8.00 **\*8\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>127</u>	0.00							
<b>*150*</b>									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

12/2/27 (9)

0002-27 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, January 25, 2012 11:59:08 AM

Page 1

Work Order ID: 79341

**\*79341\***

Parent Item: D4106-4

**\*D4106-4\***

Parent Item Name: Crew Door Doulber, RH

Start Date: 1/25/2012

Required Date: 2/3/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 10.09.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S18GA		Purchased	No			100	sf	468.0050	0.2006	1.689263			
-----------	--	-----------	----	--	--	-----	----	----------	--------	----------	--	--	--

**\*M304S18GA\***

304/316 .050 Sheet

\*\*

B12-2-21

Location

Loc Qty

Loc Code

MAT020

468.005

119032

49.3

119383

96

119766

66.705

120243

256

119766

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	79341
<b>Description:</b> Crew Door Doubler, RH		<b>Part Number:</b>	D4106-4
<b>Inspection Dwg:</b> D4106 <b>Rev:</b> A		<b>Page 1 of 2</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	0.131	✓		VIB62	
Ø0.375	+0.006/-0.001	0.376	✓		✓	
2.63	+/-0.030	2.629	✓		✓	
4.88	+/-0.030	4.886	✓		✓	
5.92	+/-0.030	5.934	✓		✓	
5.26	+/-0.030	5.262	✓		✓	
0.25	+/-0.030	0.251	✓		✓	
1.04	+/-0.030	1.041	✓		✓	
1.84	+/-0.030	1.840	✓		✓	
2.45	+/-0.030	2.454	✓		✓	
2.63	+/-0.030	2.643	✓		✓	
2.94	+/-0.030	2.943	✓		✓	
3.42	+/-0.030	3.424	✓		✓	
3.93	+/-0.030	3.936	✓		✓	
4.03	+/-0.030	4.037	✓		✓	
4.21	+/-0.030	4.211	✓		✓	
4.71	+/-0.030	4.708	✓		✓	
4.79	+/-0.030	4.791	✓		✓	
5.01	+/-0.030	5.011	✓		✓	
5.13	+/-0.030	5.130	✓		✓	
5.67	+/-0.030	5.668	✓		✓	
1.16	+/-0.030	1.161	✓		✓	
2.05	+/-0.030	2.051	✓		✓	
2.86	+/-0.030	2.860	✓		✓	
3.37	+/-0.030	3.370	✓		✓	
3.48	+/-0.030	3.480	✓		✓	
3.87	+/-0.030	3.869	✓		✓	
4.57	+/-0.030	4.568	✓		✓	
5.07	+/-0.030	5.066	✓		✓	
5.37	+/-0.030	5.361	✓		✓	
0.96	+/-0.030	0.962	✓		✓	
1.10	+/-0.030	1.103	✓		✓	
1.67	+/-0.030	1.671	✓		✓	
1.81	+/-0.030	1.814	✓		✓	
1.95	+/-0.030	1.955	✓		✓	
2.38	+/-0.030	2.384	✓		✓	
2.41	+/-0.030	2.412	✓		✓	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



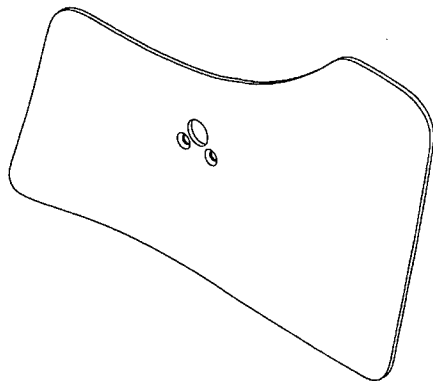
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

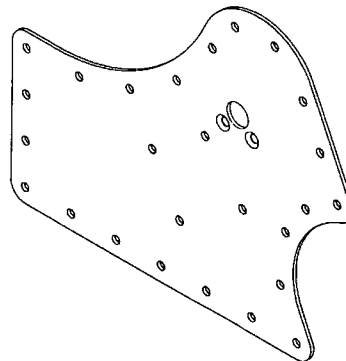
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

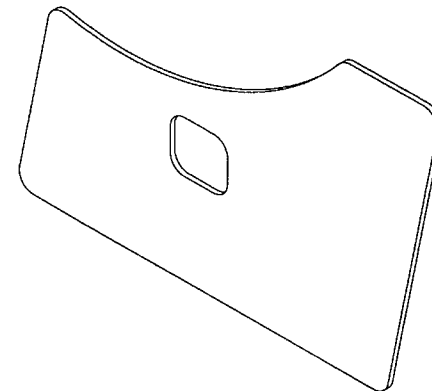
**NOTE:** Date & initial all entries



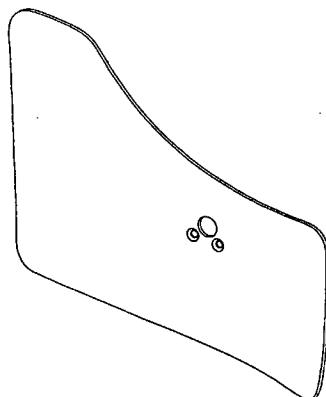
**D4106-1 SILL DOUBLER, LH**



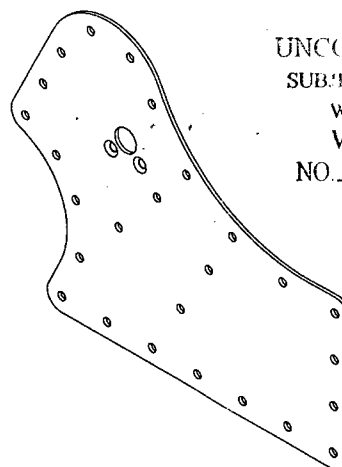
**D4106-3 CREW DOOR DOUBLER, LH**



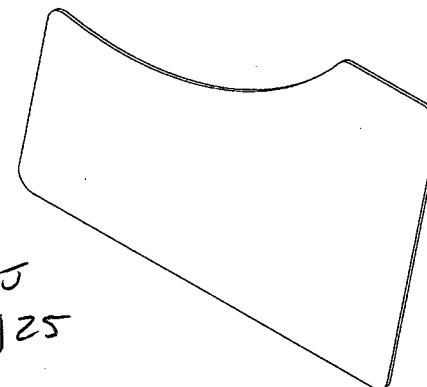
**D4106-5 SPACER, SILL DOUBLER**



**D4106-2 SILL DOUBLER, RH**



**D4106-4 CREW DOOR DOUBLER, RH**



**D4106-7 TEMPLATE**

STOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 79341 M.C.J

12/01/25

**RELEASED**  
2010-09-23  
JMM

REV.	NEW ISSUE	DESCRIPTION	JPH	10.07.15
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	BY	DATE
DRAWN	JPH			
CHECKED		DRAWING NO. <b>D4106</b>		REV. A
MFG. APPR.		TITLE <b>DOUBLERS</b>		SHEET 1 OF 5
APPROVED				SCALE
DE APPR.				NTS
DATE	10.07.15	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

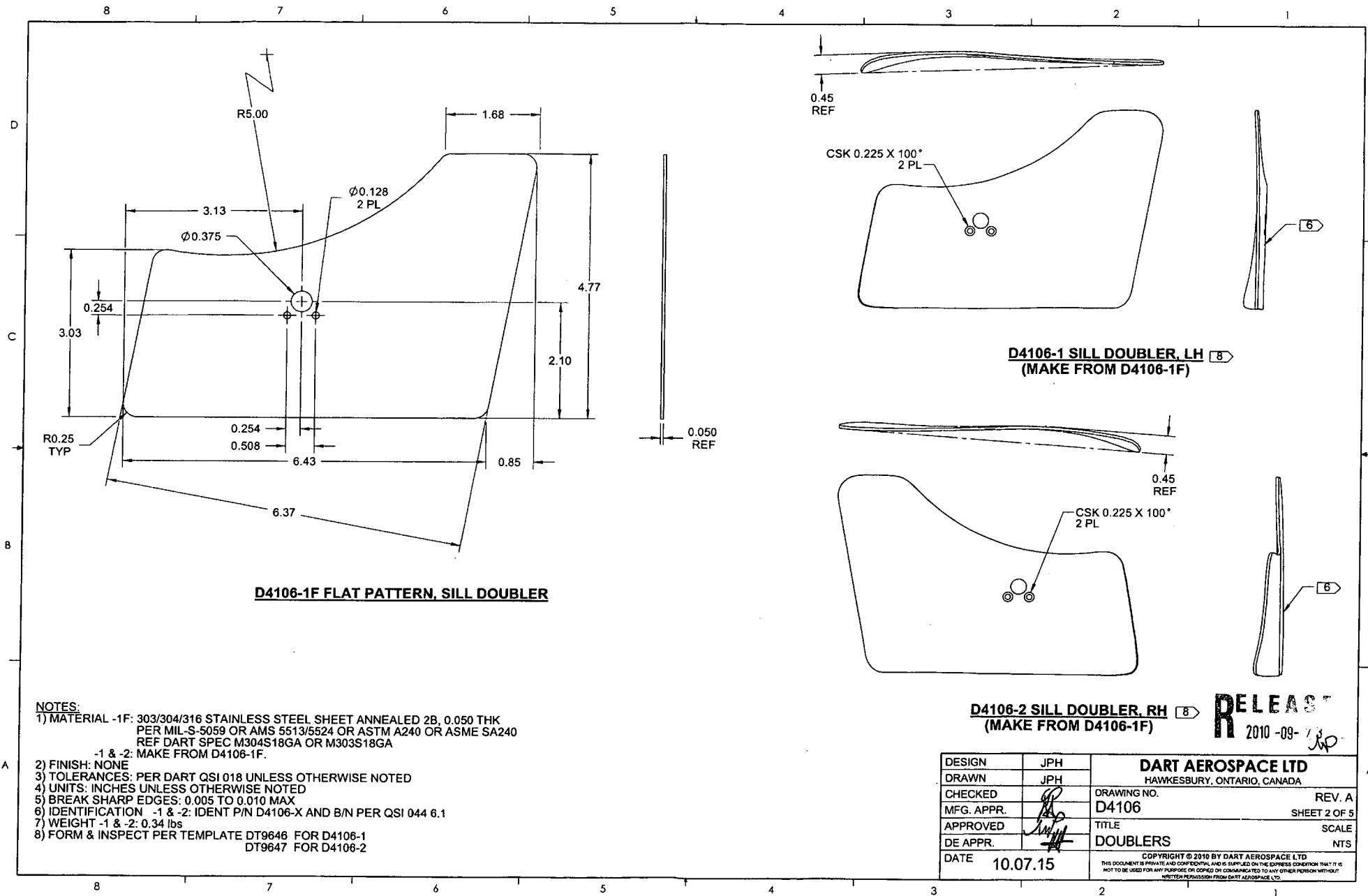
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

79341



**D4106-1F FLAT PATTERN, SILL DOUBLER**

**NOTES:**

- 1) MATERIAL -1F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.050 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S18GA OR M303S18GA
- 1 & -2: MAKE FROM D4106-1F.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION -1 & -2: IDENT P/N D4106-X AND B/N PER QSI 044 6.1
- 7) WEIGHT -1 & -2: 0.34 lbs
- 8) FORM & INSPECT PER TEMPLATE DT9646 FOR D4106-1  
DT9647 FOR D4106-2

**D4106-2 SILL DOUBLER, RH 8**  
(MAKE FROM D4106-1F)

**RELEASE**  
2010-09-13

DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. A
MFG. APPR.	JPH	D4106	SHEET 2 OF 5
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	DOUBLERS	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

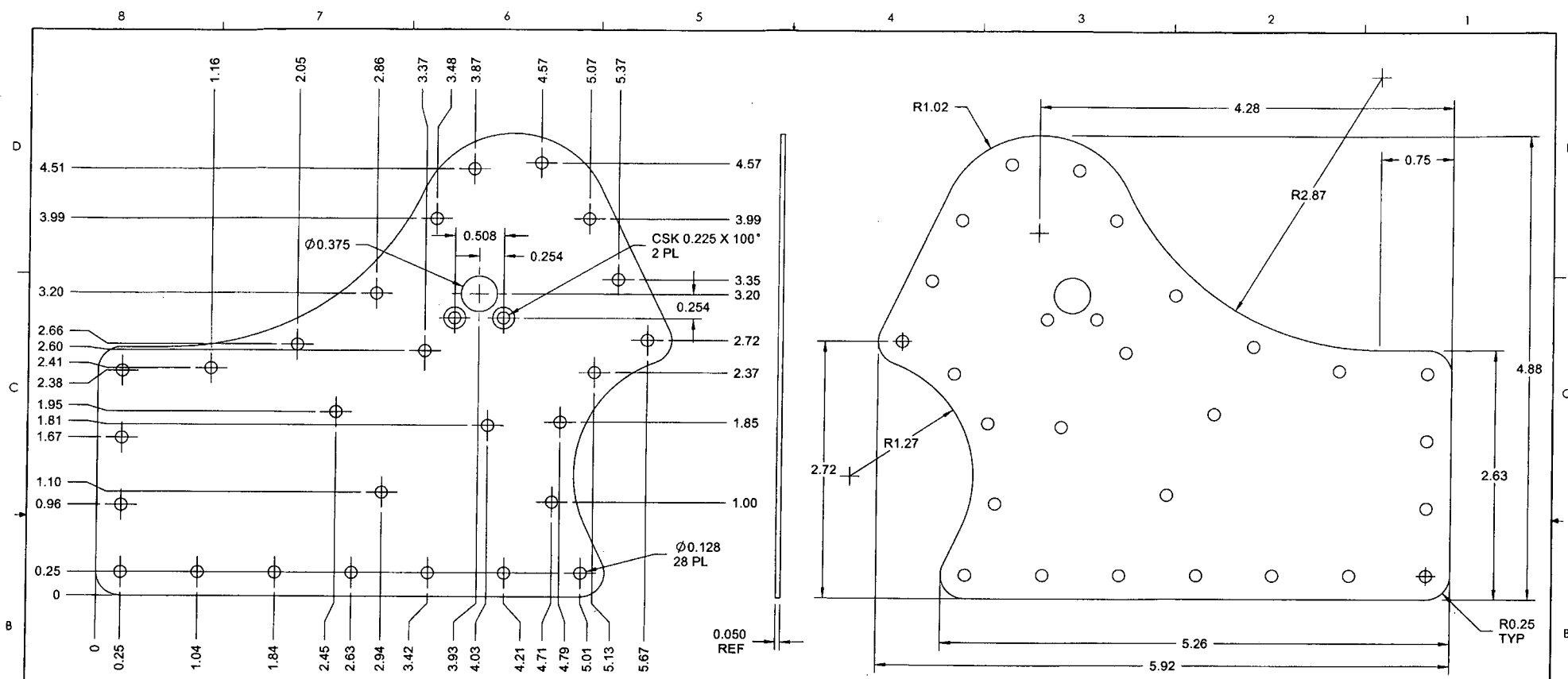
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



79341



**D4106-3 CREW DOOR DOUBLER, LH**

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.050 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S18GA OR M303S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4106-3 AND B/N PER QSI 044 6.1
- 7) WEIGHT: 0.27 lbs

**RELEASED**  
2010-09-23

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D4106</b>	SHEET 3 OF 5
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W/O:		WORK ORDER CHANGES					
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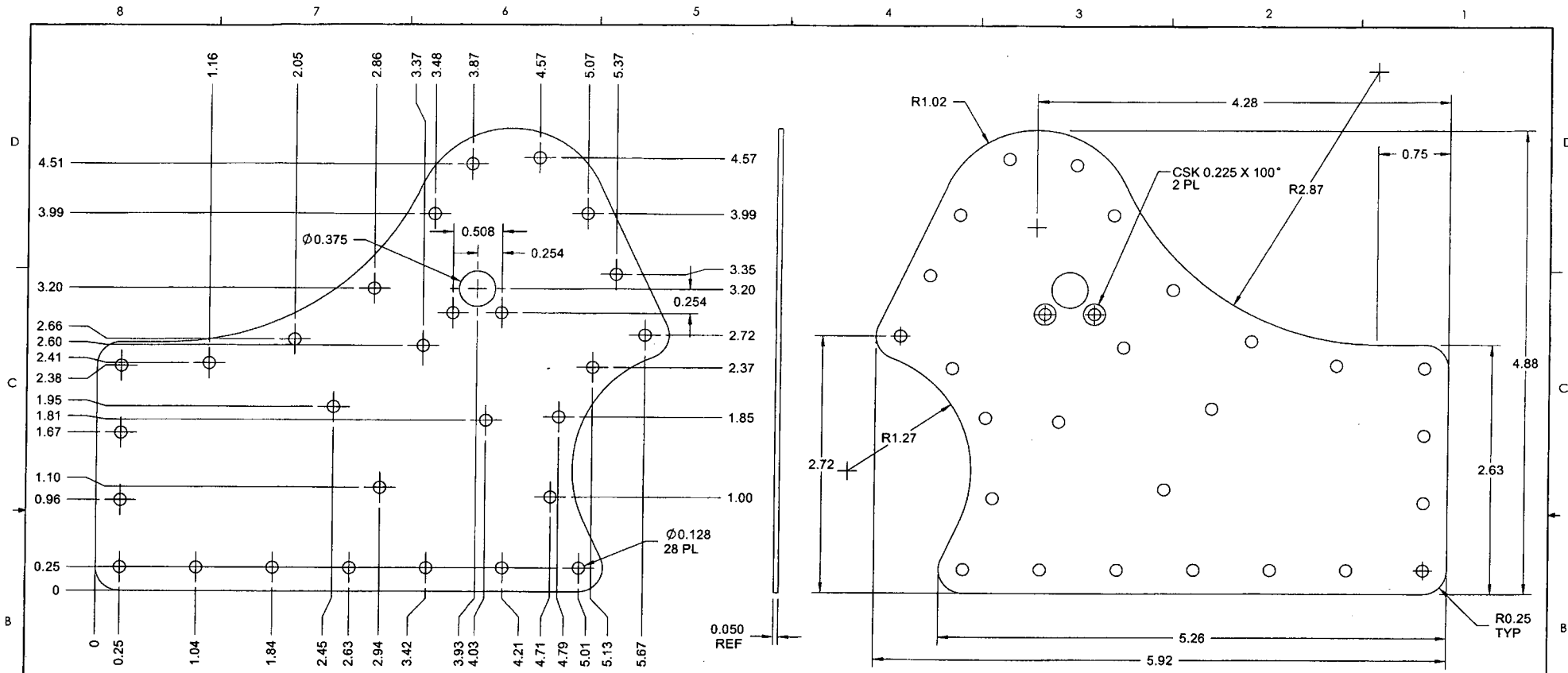
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**D4106-4 CREW DOOR DOUBLER, RH**

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.050 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S18GA OR M303S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4106-4 AND B/N PER QSI 044 6.1
- 7) WEIGHT: 0.27 lbs

RELEASED  
2010-09-23

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4106	SHEET 4 OF 5
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

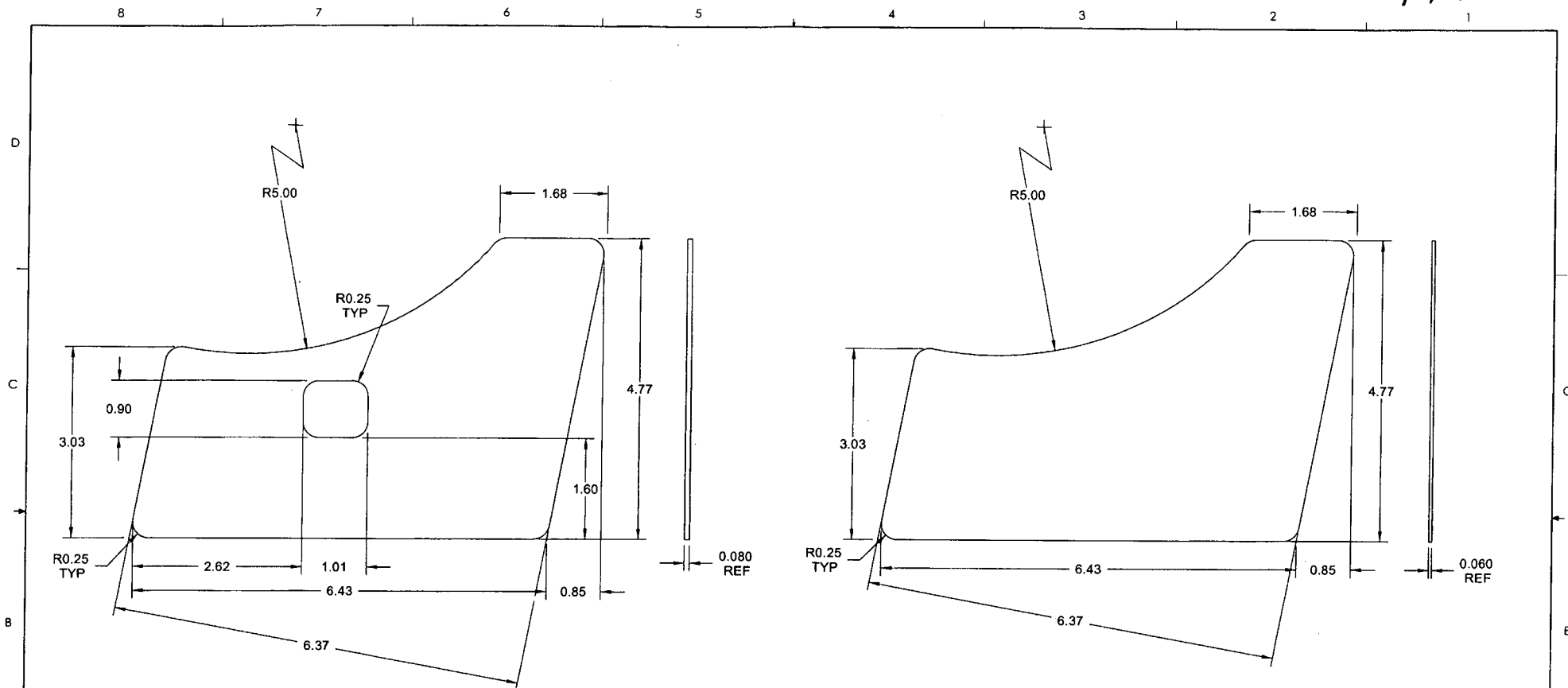
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

79341



**D4106-5 SPACER, SILL DOUBLER**

**D4106-7 TEMPLATE**

**NOTES:**

- 1) MATERIAL -5: KYDEX 6185 SHEET, 0.080 THK  
REF DART MKYD6185S.080-P3-52068 OR MKYD6185S.080-P3-62015
- 7: LEXAN 9034 SHEET, 0.060 THK  
REF DART MLEXS.060-9034-08
- OR POLYCAST-II CLEAR ACRYLIC, .060 THICK.  
REF DART M-ACRYLIC-S.060

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4106-X PER QSI 044 6.1
- 7) WEIGHT -5: 0.08 lbs  
-7: N/A

**RELEASED**  
2010-09-23  
NP

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4106</b>	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 5 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>DOUBLERS</b>	NTS
DATE	10.07.15	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries